ASAP - one next pls.

Work Order ID 107498 September-26-13 11:48:03 AM				*107498*							Page 1
Item ID: Revision ID:	D3189-1			Accept	*N900	040	100)* ፡	Setup Sta	i	S1*
Item Name:	Chaffing Shiel	d							Sto	^{υρ} *Ν	S2*
Start Date:	9/26/13	Start Qty: 20.00	· *2 ()*	Cust Item 1	ID:					
Required Date: Reference:	: 10/10/13	Req'd Qty: 20.00	*20)*	Customer:						,
Approvals:	Process Pla	n:MLJ	Date: 13-09	-26 Tooling:	D	ate:		F	Run Sta	I/I	R1*
	QC:	· · · · · · · · · · · · · · · · · · ·	Date:	SPC (Y/N):	D:	ate:	,		Sto	^{₀p} *N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr				,					
D3189	C										
¹00 *1∩∩`*		SHEAR		0.00				20	0		Im309.2
Waterjet FLOW CNC Waterj	at	Memo		0.00							
rlow ene water	ei	1-Cut as p Dwg Rev: Prog Rev:	er Dwg								
		2-Deburr	f necessary								
103	*	QC2- Inspect parts off	machine FAI/FAIB	0.00							

0.00

Memo

QC

Quality Control

							•			DQA:	Date:	:	
NCR: Y	es / No				WORK ORE	DER NON-C	ONFOR	MANCE / UP	DATE	QA Closed:	 Date:		•
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Work Orde	àr.				DISPO	SITION			AGAINST DE	PARTMENT	/PROCESS		
WOIK OIGC	-1.					Rework		Skid-tube	Crosstube	1	Water let	Engineering	
Part N	lo.					Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
						Use-as-is X	1	noforming	Finishing	4	re/Packaging	Other	
NCR N	lo				Work Ord	er Update		Large Fab	Composite]	Supplier		
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Cause	Date	Step	Qty		or Non-conforma	ance	Chief Eng	Desc	cription	Date	Verification	QC Inspector	_
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	Bending				Bend		Grain		•	Ovalized		Pressure/Forced	
	Centre N	lot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damag	ed	Inspecti	on incomplete		Part Incorre	ct	Weld	
·	Crushed	/Crimped			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
ľ	Cuffs				Contamination		Mainte	enance		Part Moved		·	
	Heat Tre	at			Countersink		Mislabe	eled		Positioned V	Vrong	_	
	Inspection	Inspection Strip in Tube Cut Too Short			Misread			Power Loss/	Surge	Other			
1	Rinnles i	n Rand			Drill Holes		Offset			_			

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

107498

Page 2

September-26-13 11:48:03 AM Accept Item ID: D3189-1 *N900040100* Setup Start **Revision ID:** Stop Chaffing Shield Item Name: **Start Qty: 20.00 Start Date:** 9/26/13 **Cust Item ID:** Required Date: 10/10/13 Req'd Qty: 20.00 **Customer:** Reference: Start Run Process Plan: Tooling: Approvals: Date: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Reject Tool # Plan Accept Insp. **Work Center ID Description** Code Qty **Run Hours** Qty Number Stamp 105 QC8- Inspect parts - second check DAS ∞ *105* 27 Memo Quality Control 110 0.00 Small Fab *110* Small Fab 0.00 Memo Small Fab 1- Roll as per Dwg D3189 120 QC5- Inspect part completeness to step on W/O 0.00 *120* 13-10-01 QC 0.00 Memo Quality Control

NCR: Y	es / N	ס			WORK ORDER NON-C	100	NFORM	MANCE / UPI	DATE			
										QA Closed:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	_
Part No					Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			Finishing	Pro Rec/Stoi	Engineering Quality Other		
Root				Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data												(
Equip/Tooling												
Operator												
Material												
Setup									•			
Other					•							,
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	Cracks			-	Broken/Damaged	-	1	on Incomplete		Part Incorred	-	Weld
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	Heat T	reat tion Strip ii	a Tuba	-	Countersink Cut Too Short	-	Mislabe Misread		—	Positioned V Power Loss/	· -	Other
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Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

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	rder ID 107498	*10	749
Item ID:	D3189-1	Accept	*N

Work Ord September-26-1			*107498*									Page 3
Item ID: Revision ID: Item Name:	D3189-1 Chaffing Shie	eld		Accept	*N900	040	100)* s	etup	Start Stop	ı vı,	S1* S2*
Start Date: Required Date: Reference:	9/26/13 10/10/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:					14.	. 17
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:		R	lun	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 130 *130* Packaging Packaging	D	Operation Description Identify as per dwg & Sto	ck Location: <u>LG5</u> 3	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty 20	Rej Qty		Reject Number	Insp. Stamp Ad 13-10-3
*140 *140* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00					97	H	']3-1 N	04 NF 101

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											QA Closed:	Dat	e:
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Part No. NCR No.			Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			ıb	Pro Rec/Stor	Engineering Quality Other					
Root					Descri	ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	n QC Inspector
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Other	Н										•		
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	Ш	Cracks		•		Broken/Damaged		- 1 ` .	on Incomplete		Part Incorred	ct [Weld
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	Ш	Ripples in	Bend			Drill Holes		Offset					
Torque Waves in Extrusion Drawing				Out of C	Calibration								

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

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Picklist Print

September-26-13 11:48:09 AM

Work Order ID: 107498

107498

Parent Item:

D3189-1

D3189-1

Parent Item Name: Chaffing Shield

Start Date: 9/26/13

Required Date: 10/10/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP B05.08.22No longer made in-houseKJ/JLM

IPP Rev:C 06-03-24 Rolling Now made in House JLM

IPP Rev:D 07-04-16 As per Rev B JLM

IPP Rev:E

11.05.11 now made on waterjet DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA 2	1	Purchased	No			100	sf	0.0000	0.32	6. 7368 42			
M30452	ŚGA								**	7.0			JM13-09-3

304/316 :020" Sheet

											DQA:	Dat	e:		
NCR: Y	es / No				WORK ORDER NON-	CONFO	DRMAI	NCE / UP	DATE		QA Closed:	Dat	e:		
Work Orde	.r.				DISPOSITION				DE	PARTMENT,	/PROCESS				
Part No. NCR No.				Scrap N Use-as-is Therm		Macl nermofo	Skid-tube Crosstube lachining Small Fab oforming Finishing arge Fab Composite				Water Jet		Engineering Quality Other		
Root	D-1-	Chara	0+		iption of work order update	Initia	l l		tion		Sign &	Verification		OC Increases	
Cause	Date	Step	Qty		or Non-conformance	Chief I	Engl	Desc	ription		Date	verification	' -	QC Inspector	
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	Cracks			L	Broken/Damaged	Insp	ection Ir	ncomplete			Part Incorred	ct _	_	/eld	
	-	/Crimped		L	Burrs	\vdash		Incomplete/	'Unclear		Part Lost/Mi	ssing]^	rong Stock Pulled	
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DART AEROSPACE LTD	Work Order:	107478
Description: Chafing Shield	Part Number:	D3189-1
Inspection Dwg: D3189 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.38	+/-0.030	4.386-	_		V	Jenoi
12.00	+/-0.030	12.004	-		Τ	Jamos Jamos
0.020	+/-0.010	12.004	_		✓	
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	DAS	· · · · · · · · · · · · · · · · · · ·
Measured by: JM	Audited by: 27	Preliminary Approval:
Date: (3-09-30	Date: 13 9 30	Date:

Rev	Date	Change	Revised by	Approved
Α	11.06.21	New Issue	KJ ∖	2/
В	12.09.26	Dimensions updated per Dwg Rev C	KJ A	Chil
			7.7	7 /

						•					DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UP	DATE			
									·		QA Closed:	Date:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
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Part I	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1		noforming	Finishing	-	re/Packaging	Other
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		Bending			_	Bend	L	Grain			Ovalized	<u> </u>	Pressure/Forced
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1	Cracks					Broken/Damaged	1	Inspection Incomplete			Part Incorre	ct	Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

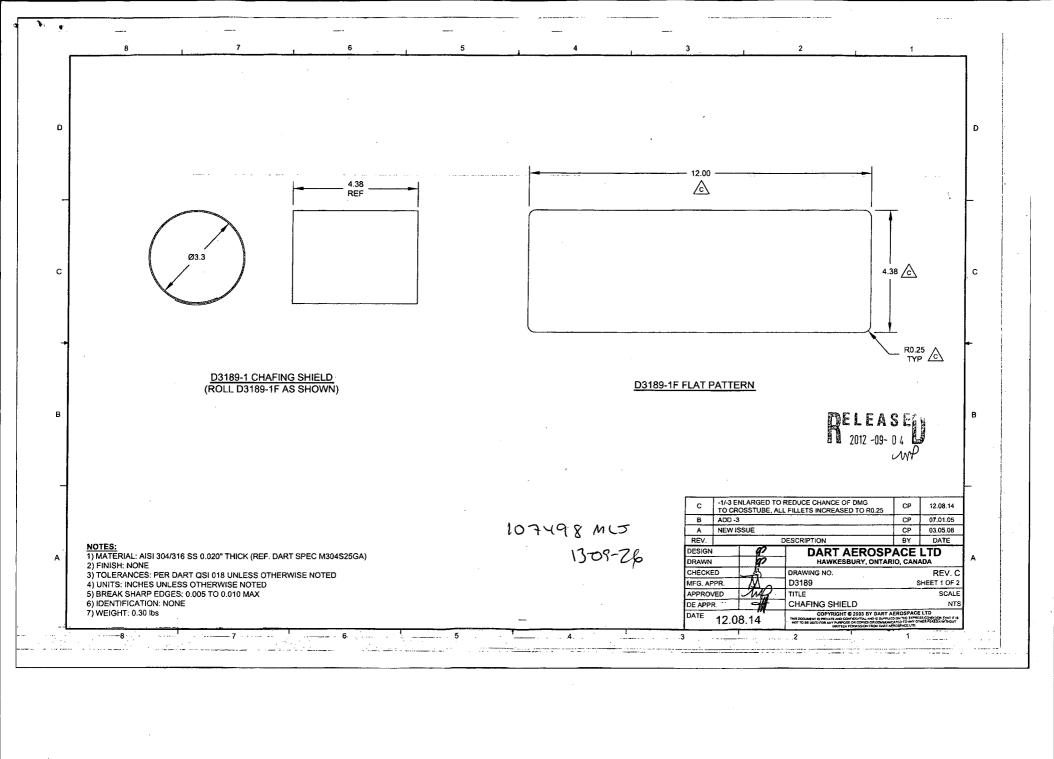
Countersink

Cut Too Short

Drill Holes

Drawing

Finish



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Work Orde	s ė .				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
WOIK OIGC					Rework	Skid-tube Crosstube			1	Water Jet	Engineering			
Part N	lo.				Scrap	Machining Small Fab Thermoforming Finishing			Pro	d. Eng. Coor.	Quality			
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NCR N	lo				Work Order Update	1		Large Fab	Composite		Supplier			
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Out of Sequence

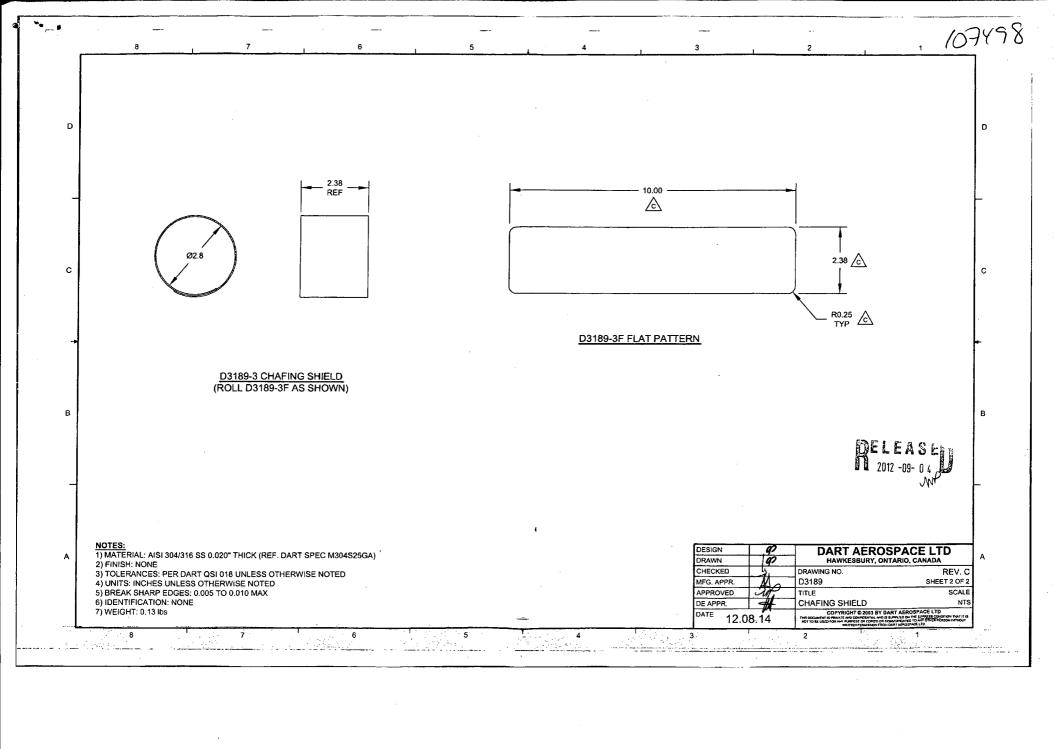
Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



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NCR:	Yes	/	No	

		70				-				DQA:	Date	:	
NCR: Y	es / No		1	•	WORK ORDER NON-	-COI	NFORI	MANCE / UPDATE	. •	QA Closed:	Date	•	
Work Orde	The state of the s			DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No.				Rework Scrap		Skid-tube Crosstube Machining Small Fab			Water Jet Prod. Eng. Coor.		Engineering Quality		
NCR No.				Use-as-is Work Order Update		Thermoforming Finishing Composite			Rec/Store/Packaging Other Supplier				
Root				Descr	iption of work order update		Initial	Action		Sign &		·	
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						-1	tions Incomplete/Unclear	Ш	Part Lost/Mi	ssing	Wrong Stock Pulled		
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7). ·	Torque W			n _	Drawing	<u> </u>	4	Calibration				* <u>*</u> **	
Ļ	Turning S			<u> </u>	Finish	<u> </u>	4	Sequence	-				
Wave/Twist in Tube					Folio	Outside Dimensions							